



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 173613



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	10 pcs	7/19/18	7/19/18	0.00	9.91	Large Fab 2		SLU
120	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC9		SA 2018-06-12
130	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		SA 2018-06-12
140	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.84	HandFinish1		SA 18-06-13
150	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC7-2		CPL
180	Large Fab	10 pcs	7/19/18	7/19/18	0.00	9.91	Large Fab 2		SLU
190	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC10		EB
200	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		EB
210	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.84	HandFinish1		SA 18-06-14
220	Powdercoat	10 pcs	7/19/18	7/19/18	0.00	2.90	Powdercoat1		BE 18-06-15
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish3		BE 18-06-18
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		38
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		9-85
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		DAS
265	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		58
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		9-89
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21 18-06-19

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134765 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 10:15 OVEN TEMPERATURE: 300 FINISH TIME: 11:45

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk 5080993.

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	S069554 → 12x
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	S070370 → 8x
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	S068282 → 3x S068282 → 17x
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	S074069
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	S099036
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	S070395 x 14
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	S041171
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	41	0
	D3219-1	20	55	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	22	0
	D3066-1	20	10	0
	MS20600-AD4W4	160	1,681	0
250-Packaging	AN3-35A	20	312	0
	AN4-13A	80	941	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	214	0
	D2856-400-720	20	197	0
	D3235-1	20	6	0
	D3278-041	10	7	0
	MS21042L3	20	3,284	0
	MS21042L4	80	3,884	0
	MS21042L5	20	849	0
	NAS1149D0363J	40	3,378	0
	NAS1149D0463J	160	5,081	0
	NAS1149D0563J	40	1,290	0

Part Specifications

Specifications could not be found.

Plex 3/5/18 4:07 PM Dart.Gagnon.Michelle

90- 3811
180- 3852



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Container No: S080055



Part: D350-591-311

Job No: 173613

Serial No/Batch: S080055

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/12/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003871	S081318	AN3-35A	Bolt	S047337	ST348	20
003871	S081317	AN4-13A	Bolt	s067892	OVER003	80
003871	S048292	AN5-36A	Bolt		ST336	8
003871	S081316	AN5-36A	Bolt	s068656	ST336	12
003871	S081311	D2230-3	Mounting Lug	s080361	ST521	40
003871	S081310	D2618	Bushing	s049859	ST008	20
003871	S081309	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	20
003871	S081308	D3235-1	Mounting Lug	s053650	ST522	20
003871	S081307	D3278-041	Support Assembly	s076688	ST522	10
003871	S081302	MS21042L3	Nut	s078167	OVER007	20
003871	S081301	MS21042L4	Nut	s078254	ST303	80
003871	S081300	MS21042L5	Nut	s058178	ST303	20
003871	S081295	NAS1149D0363J	Washer	s015269	ST263	40
003871	S055952	NAS1149D0463J	Washer	s067900	ST263	97
003871	S081230	NAS1149D0563J	Washer	s068662	Large Fab 2	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.